

Work Order ID 142445

March 09, 2016 2:15:47 PM

142445

Page 1

Item ID: D2562-001 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut 19.68"
Start Date: 3/10/2016 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 3/15/2016 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: SLA 20160309 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2562	Rev D								

100		0.00							
100	NC BRAKE					8	FF		MAR 10 2016
Brake NC	Memo	0.03							
Brake NC	Punch to length as per Dwg D2562								

110		0.00							
110	Small Fab					8	FF		MAR 10 2016
Small Fab	Memo	0.03							
Small Fab	1- Bend end as per Dwg D2562 Angle "D"2-Debur								

120		0.00							
120	QC5- Inspect part completeness to step on W/O								DAS
QC	Memo	0.00				8			38
Quality Control									9-89

MAR 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M 133962</i> Memo START TIME: <i>9:25</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>9:55</i>	0.00 0.00				<i>8</i>	<i>0</i>	<i>16-03-11</i>	<i>238</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(8)</i>			<i>DAS</i> <i>38</i> <i>9-89</i> MAR 11 2016
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>5135B</i> Memo	0.00 0.00				<i>8</i>			<i>DAS</i> <i>6</i> <i>9-89</i> MAR 11 2016

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
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Page 3

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Strut 19.68"

Stop ***NS2***

Start Date: 3/10/2016 Start Qty: 8.00

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Cust Item ID:

Required Date: 3/15/2016 Req'd Qty: 8.00

g

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.01

Quality Control

MCJ MAR 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

March 09, 2016 2:15:52 PM

Page 1

Work Order ID: 142445

142445

Parent Item: D2562-001

D2562-001

Parent Item Name: Strut 19.68"

Start Date: 3/10/2016

Required Date: 3/15/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP F02.04.15Added dwg Rev.B1 NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.035

Purchased

No

100

f

59.7695

1.7067

14.37221

M304TR0 500W 035

MAR 10 2016

304 RD Tube .500 x .035W

Location

Loc Qty

Loc Code

GA

32.579

m133509

32.579

GA002

27.1904714

m128495

4.14737

m132775

2

m132872

8.6822064

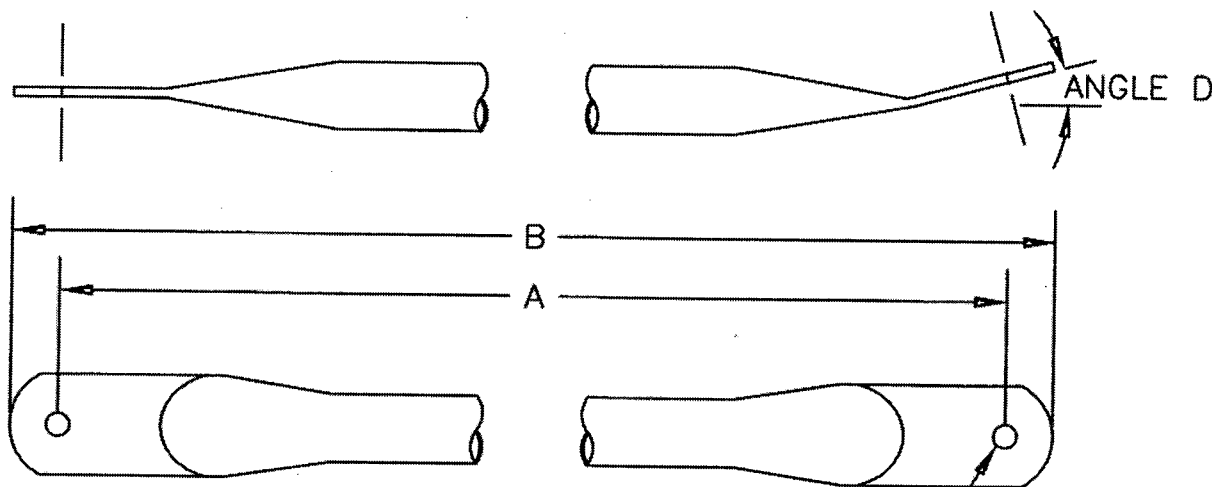
m133611

12.360895

14.37221



DESIGN	DRAWN BY	DART AEROSPACE LTD	
CP	RF	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D2562	SHEET 1 OF 1
DATE	TITLE	SCALE	
05.05.18	STRUT	1:2	
A	96.05.01	NEW ISSUE	
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)	
C	02.06.05	ADD -005; ADD FINISH	
D	05.05.18	ADD -007/-011/-013; UPDATE -005	



PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035) ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

20160309
SA
142445

RELEASED
06.05.27

